



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G08131-3G-PO
Job Sheet 185424



Part No: RBW6205G08131-3G-PO **Job Qty:** 1 ea

Part Name: Main Rotor Flanged Bushing Install Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 12/17/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G08131-3G Rev.2 IPP Rev. A 18.10.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs		12/17/18	0.00	0.00	Purchasing		
110	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging2		
120	QC	1 pcs		12/17/18	0.00	0.00	QC6		
130	Packaging	1 pcs		12/17/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		12/17/18	0.00	0.00	QC21		

Part Op 100 - Issue P/O: 041367 MANUFACTURE RBW6205G08131-3G AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G08131-3GP	Main Rotor Flanged Bushing Install Tool	1 (1 ea)	100-Purchasing	5137952

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G08131-3GP	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/26/18 8:45 AM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1-613-632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S137953



Part: RBW6205G08131-3G

Job No: 185424

Serial No/Batch: S137953

Revision: 2

Inspector:

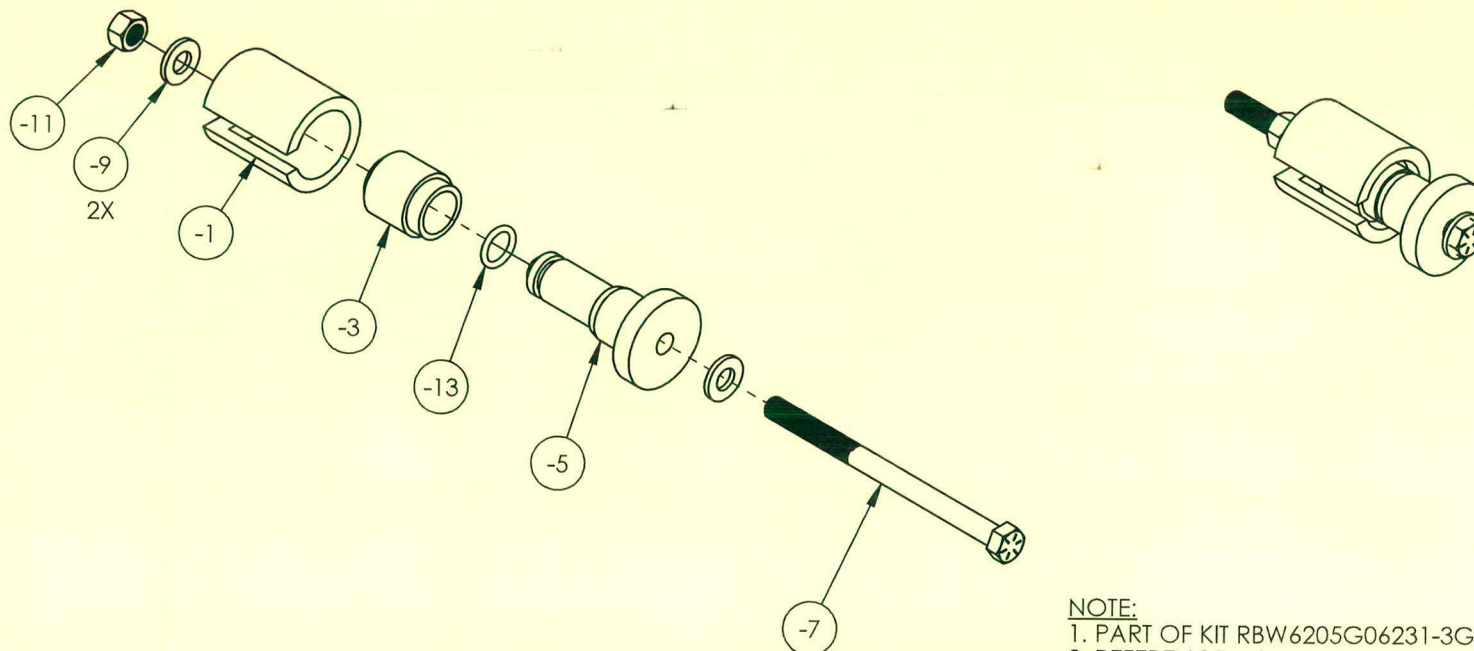
Exp Date:

Instructions:

Date: 12/17/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		BROKE OUT INTO INDIVIDUAL TOOL FROM RBW6205G06231-3G.	4/7/2011	RJC	
B		CORRECTED -5 ENGRAVE NOTE FROM "RBW6205G08131-3G".	9/25/2012	RJC	SE
2	17-0050	UPDATED TO NEW DRAFTING STANDARD. ADDED NOTE 2 SHEET 1. -1 ADDED DIM FULL R. -3, -5 CH'D MATERIAL WAS 4140 IS 4140/4142, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE I SC2. -5 CH'D DIMS WAS Ø2.200 IS Ø2.20, WAS Ø1.021±.002 IS 2X Ø1.021±.002. -7 CH'D B/O PN WAS MCMASTER-CARR #91257A497 IS FASTENAL #18233, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE I SC2.	2/15/2017	RJC	JAG



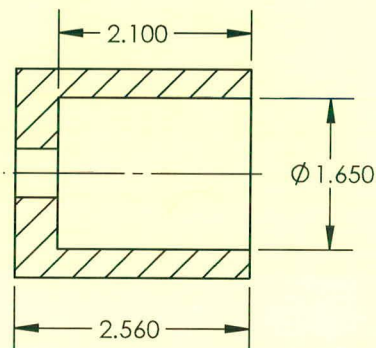
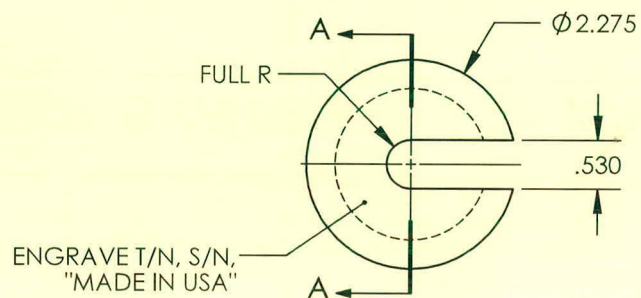
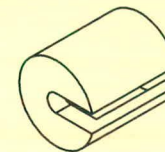
NOTE:
1. PART OF KIT RBW6205G06231-3G.
2. REFERENCE AGUSTA T/N 3G6205G08131.

DART AEROSPACE	
TITLE M/R FLANGED BUSHING INSTALLER	
DWG NO. RBW6205G08131-3G	REV 2
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	AW139
APPROVED: GILBERT	
SCALE 1:4	DATE 4/7/2011 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	6061		2
			-3	1	GUIDE	4140/4142		3
			-5	1	PRESS	4140/4142		4
			-7	1	BOLT	STEEL, GRD 8	1/2-20 X 10 (FASTENAL #18233) MODIFIED	5
		B/O	-9	2	WASHER	STEEL	Ø1/2 I.D. (MCMASTER-CARR #90126A033)	1
		B/O	-11	1	HEX NUT	STEEL GRD 8	1/2-20 UNF (MCMASTER-CARR #94895A825)	1
		B/O	-13	1	O-RING	VITON	1/8 C.S. X 3/4 I.D. 1 O.D. (MCMASTER-CARR #9464K31)	1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0050	•1 ADDED DIM FULL R.	2/15/2017	RJC	JAG



SECTION A-A

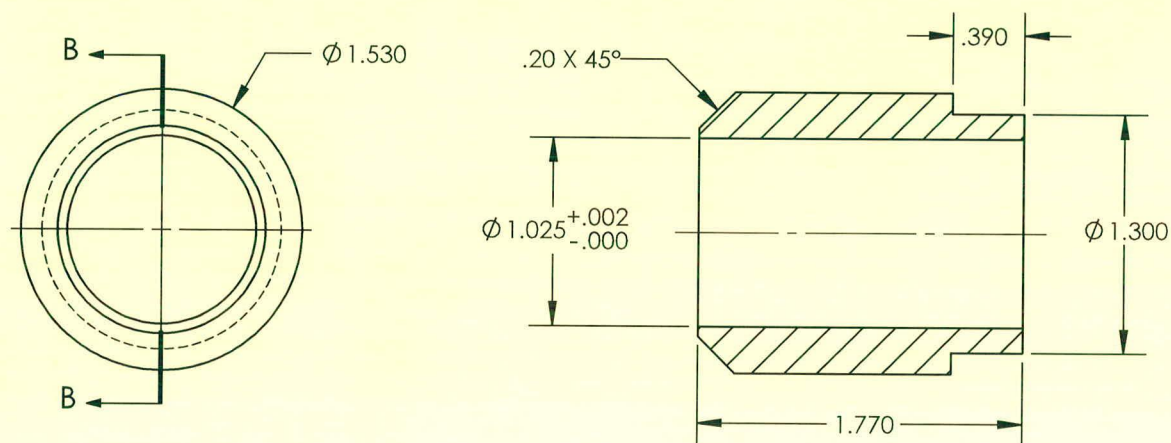
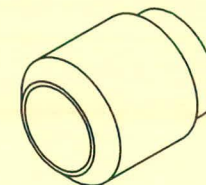
(-1)

RECEIVER

DART AEROSPACE	
TITLE M/R FLANGED BUSHING INSTALLER	
DWG No. RBW6205G08131-3G-1	REV 2
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625F, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 4/7/2011	AW139
	SHEET 2 OF 5

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	17-0050	-3 CH'D MATERIAL WAS 4140 IS 4140/4142, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE 1 SC2.			2/15/2017	RJC	JAG



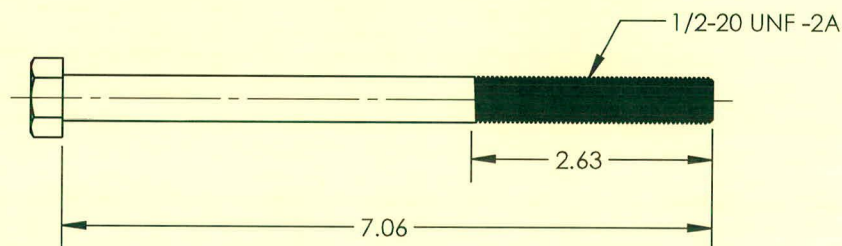
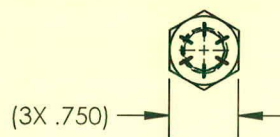
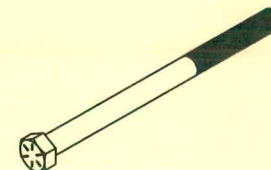
SECTION B-B

(-3)
GUIDE

DART AEROSPACE	
TITLE M/R FLANGED BUSHING INSTALLER	
DWG NO. RBW6205G08131-3G-3	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± 5°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:1	DATE 4/7/2011
SHEET 3 OF 5	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0050	-7 CH'D B/O PN WAS MCMASTER-CARR #91257A497 IS FASTENAL #18233, CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC ASTM B633 TYPE I SC2.	2/15/2017	RJC	JAG



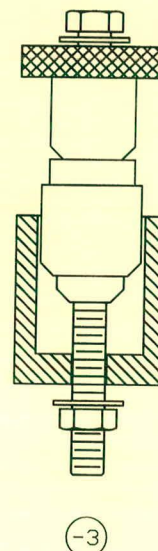
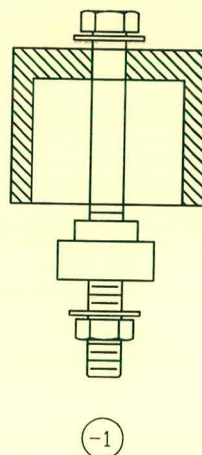
(-7)

BOLT

DART AEROSPACE	
TITLE M/R FLANGED BUSHING INSTALLER	
DWG NO. RBW6205G08131-3G-7	REV 2
MAT'L STEEL, GRD 8	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 4/7/2011	AW139
SHEET 5 OF 5	

This drawing, specifications, and concepts contained here in are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	BROKE OUT INTO INDIVIDUAL TOOLS & LISTED EACH TOOL IN BOM PER RW.	4/7/11	RJC	
1	CH'D -7 FOAM CUT OUT FOR RBW6205G08131-3G FOR A BETTER FIT PER S.E.	3/7/12	RJC	SE



RED BARN MACHINE	
TITLE M/R FLANGED BUSHING R&R	
DWG NO. RBW6205G06231-3G	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 3-24-10
SHEET 1 of 4	

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	M/R FLANGED BUSHING REM.		RBW6205G08031-3G	1
			-3	1	M/R FLANGED BUSHING INST.		RBW6205G08131-3G	1
		B/O	-5	1	CASE	PLASTIC	PELICAN #APP-1300-E BLACK	N/S
		B/O	-7	1	BOTTOM FOAM	Y20 BLACK	5.00 x 7.18 x 9.34 I.R. SPECIALTY	2
		B/O	-9	1	LID FOAM	C200 FLAT, BLACK	1.23 x 7.12 x 9.16 I.R. SPECIALTY	3
		B/O	-11	1	INSIDE PLACARD	PLASTIC	1/16 x 3-1/2 x 6 MCKENZIE LASER	4



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041367
PO Date: 10/16/18
Due Date: 12/17/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revised

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185295	RBW6005G01631-3GP			Dial Indicator Swash Plate Scissors Support REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$1,150.00/pcs	\$2,300.00
Line Item Note SIOP													
2	185392	RBW1205G00231-3Gp			Main Rotor Damper Oil Filling Adapter REV 2B	Firmed	-	12/17/18	3 pcs	0 pcs	3 pcs	\$1,000.00/pcs	\$3,000.00
Line Item Note SIOP													
3	185298	RBW6405G00332-3GP			Tail Rotor Pitch Control Adjustment Tool REV 5	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$1,500.00/pcs	\$1,500.00
Line Item Note SIOP													
4	185299	RBW6005G01531-3GP			Dial Indicator Main Rotor Damper Support REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$900.00/pcs	\$1,800.00
Line Item Note SIOP													
5	185300	RBW6405G00531-3GP			Tail Rotor Damper Length Adjustment Tool REV A	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$700.00/pcs	\$1,400.00
Line Item Note SIOP													
6	185301	RBW6405G02131-3GP			Tail Rotor Blade Damper Attachment Bushing Removal REV D	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$500.00/pcs	\$1,000.00
Line Item Note SIOP													
7	185302	RBW6205G05951-3GP			RBW6205G05951-3GP REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$450.00/pcs	\$900.00
Line Item Note SIOP													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185303	RBW3205G00151-3GP			Main Landing Gear R&R Wrench REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$400.00/pcs	\$800.00
Line Item Note SIOP ORDER 7393 22 Jan 2019													
9	185349	RBW6205G26631-3GP			Wrench, MR Scissor Retaining Nut Removal/Install REV 2	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$280.00/pcs	\$560.00
Line Item Note SIOP													
10	185352	RBW6205G26551-3GP			Main Rotor Scissor Locknut REV B	Firmed	-	12/17/18	2 Ea	0 Ea	2 Ea	\$175.00/Ea	\$350.00
Line Item Note SIOP 2X DEC 17 2018													
11	185353	RBW109-3101-58-2P			Hammer, Aluminum, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	2 pcs	0 pcs	2 pcs	\$150.00/pcs	\$300.00
Line Item Note SIOP													
12	185354	RBW109-3101-58-1P			Hammer, Steel, Blade Corrosion and Voids Detection REV 3	Firmed	-	12/17/18	1 pcs	0 pcs	1 pcs	\$150.00/pcs	\$150.00
Line Item Note SIOP													
13	185406	RBW6205G03451-3GP			Bolt Guide Removal & Install REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G ORDER 7393 22 Jan 2018													
14	185407	RBW6205G08451-3GP			Puller Bolt Removal REV 2B	Firmed	-	12/17/18	3 Ea	0 Ea	3 Ea	\$625.00/Ea	\$1,875.00
Line Item Note SUB ASSEMBLY OF RBW6205G00331-3G 3X DEC 17 2018 ORDER 7393 22 Jan 2018													
15	185423	RBW6205G08031-3GP			Main Rotor Flanged Bushing Removal Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
16	185424	RBW6205G08131-3GP			Main Rotor Flanged Bushing Install Tool REV 2	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$1,125.00/Ea	\$1,125.00
Line Item Note SUB ASSY FOR RBW6205G06231-3G 1X DEC 17 2018 ORDER 7393 22 Jan 2018													
17	185429	RBW6405G08832-3GP			Tail Rotor Bushing Install Tool As Per Dwg RBW6405G08832-3G Rev/ D	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G ORDER 7393 08 Jan 2019													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041367**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
18		RBW6405G08732-3GP			Tail Rotor Bushing Removal Tool RBW6405G08732-3G Rev. E	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$875.00/Ea	\$875.00
Line Item Note SUB ASSY FOR RBW6405G08632-3G													
19	185430	RBW6205G10451-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
20	185431	RBW6205G10551-3GP			Hammer	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
21	185432	RBW6205G10351-3GP			Guide REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
22	185433	RBW6205G10251-3GP			Threaded Rod	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
23	185434	RBW6205G10151-3GP			Pusher REV 1	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
24	185435	RBW6205G10651-3GP			Stop	Firmed	-	12/17/18	1 Ea	0 Ea	1 Ea	\$208.33/Ea	\$208.33
Line Item Note SUB ASSY FOR RBW6205G08931-3G													
25	185461	RBW6305G26631-3G-1P			Pin REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
26	185462	RBW6305G26631-3G-3P			Handle REV 2	Firmed	-	12/17/18	8 Ea	0 Ea	8 Ea	\$56.25/Ea	\$450.00
Line Item Note SUB ASSY FOR RBW6305G26631-3G													
												Grand Total: \$23,959.98	

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/29/18 8:45 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.

To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24398

Shipment Date: 17-Dec-2018

Ship Via: our truck

Order Number: 3096

Order Date: 10/17/18

Customer Code: DART

Phone: (613) 632-9577

PO Number: PO041367

Terms: Net 60 Days

Quantity						Description	Revision	Job Number
Item	Open	Shipped	B/O	Canceled	Unit			
17	1	1	0	0	EA	DART-RBW6205G08131-3GP Main Rotor Flanged Bushing Install Tool	2	3096-17

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	P.O. Number
1 ✓	DART-RBW6205G08131 ✓ 3GP	Main Rotor Flanged Bushing Install Tool	2	41367 ✓

DAS
38
9-89

MATERIAL: supplied by METEC

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

George Theoret

Vankleek Hill, December 17, 2018

CONFIDENTIAL - SECURITY INFORMATION

1534

TO: DIRECTOR, FBI (100-442655)

FROM: SAC, NEW YORK (100-100000)

SUBJECT: [REDACTED]

RE: [REDACTED]

DATE: [REDACTED]

CLASS: [REDACTED]

STATUS: [REDACTED]

REMARKS: [REDACTED]

ADMINISTRATIVE: [REDACTED]

DISPOSITION: [REDACTED]

APPROVAL: [REDACTED]

REMARKS: [REDACTED]

ADMINISTRATIVE: [REDACTED]

DISPOSITION: [REDACTED]

APPROVAL: [REDACTED]

REMARKS: [REDACTED]